

# Work Order ID 52783

October 14, 2009 10:41:17 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *BT*

Date: *09-10-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

0.00

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

If D412-742-043 is a W/O on it's own,  
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

*N/A*

**Work Order ID 52783**

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Setup Start



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Stop



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Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

\*\*\*\*\*Do not apply LPS, see QC for more info\*\*\*\*\*

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 ☒ W/N

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 ☒ M112391Expiry date: ☐ 10/20

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon". Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R ☐ LPS Procyon ☒ M104251A/R ☐ Sikaflex-241/-291 ☒ M112391Expiry date: ☐ 10/20

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

MD @ 9/11/03

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Setup Start



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Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: <u>PPP 52779</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

④ 1

09/11/05

09/11/05

MF 09-11-05

# Picklist Print

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Work Order ID: 52783

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube


Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	2,216.000	24.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2216	
112082	14	
112314	40	
112720	162	
112724	500	
112794	1000	
112829	500	

X24 mo 09/11/02

AN3C6A 		Purchased	No			110	Each	948.0000	12.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	948	
111982	948	

X12 mp 09/11/02

# Picklist Print

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Work Order ID: 52783



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C7A 		Purchased	No			110	Each	289.0000	8.0000			
BOLT												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                                              289

105906                                              21

107376                                              268

AN960C10L 		Purchased	No			110	Each	4,772.000	44.0000			
washer												

Warehouse                      Loc Qty                      Loc Code  
Location

OFFSHORE

FG                                              100

103585                                              100

Main Warehouse

ST                                              4672

112116                                              1009

112612                                              3663

D3391-021RevH 		Manufactured	No			110	Each	0.0000	1.0000			
Fwd Tube Assembly												

pulled  
on  
P3391-023  
B52792  
52788  
MF 09-11-05

X8 MD 09/11/02

X44 MD 09/11/02

X1 MD 09/11/02

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Shop Packet Print

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# Picklist Print

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Work Order ID: 52783



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3391-023RevH		Manufactured	No			110	Each	1.0000	1.0000			



Mid Tube Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	52792	
ST	1	
40522	1	

xl mp 09/11/02

D3391-025RevH Manufactured No



Aft Tube Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
39129	1	
48122	1	

50105

xl mp 09/11/02

# Picklist Print

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Work Order ID: 52783



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-1RevD		Manufactured	No			110	Each	29.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33798	2	
Main Warehouse		
ST	27	
47531	1	
48163	4	
50270	1	
51676	21	

XT MD 09/11/02

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Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube



Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-3RevD		Manufactured	No			110	Each	20.0000	1.0000			
												
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33764	2	
Main Warehouse		
FP	11	
50113	11	
Main Warehouse		
ST	7	
46445	1	
46652	3	
50364	3	

XT

mp 09/11/02



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Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			110	Each	30.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	26	
51655	15	
51925	11	
Main Warehouse		
ST	2	
45824	1	
47433	1	

52595

x1 14/10/09

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Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			110	Each	11.0000	2.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	3	
51612	3	
Main Warehouse		
ST	8	
46349	1	
51218	1	
51259	3	
52313	3	

52512

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Work Order ID: 52783



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			110	Each	25.0000	1.0000			

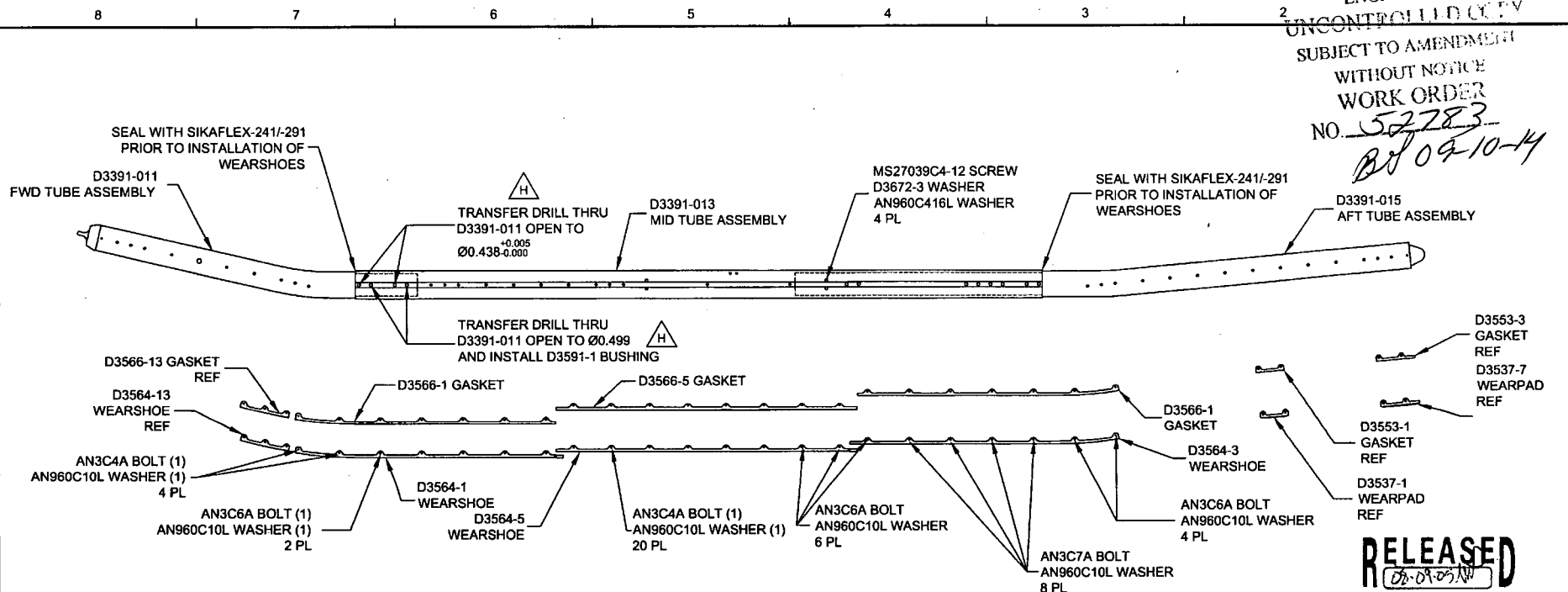


Gasket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
FP	12	
51929	12	
Main Warehouse		
FP19	9	
51669	9	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

XI MD 09/11/02

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52283  
B70910-14



D3391-041 ASSEMBLY

RELEASED  
02-09-03

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

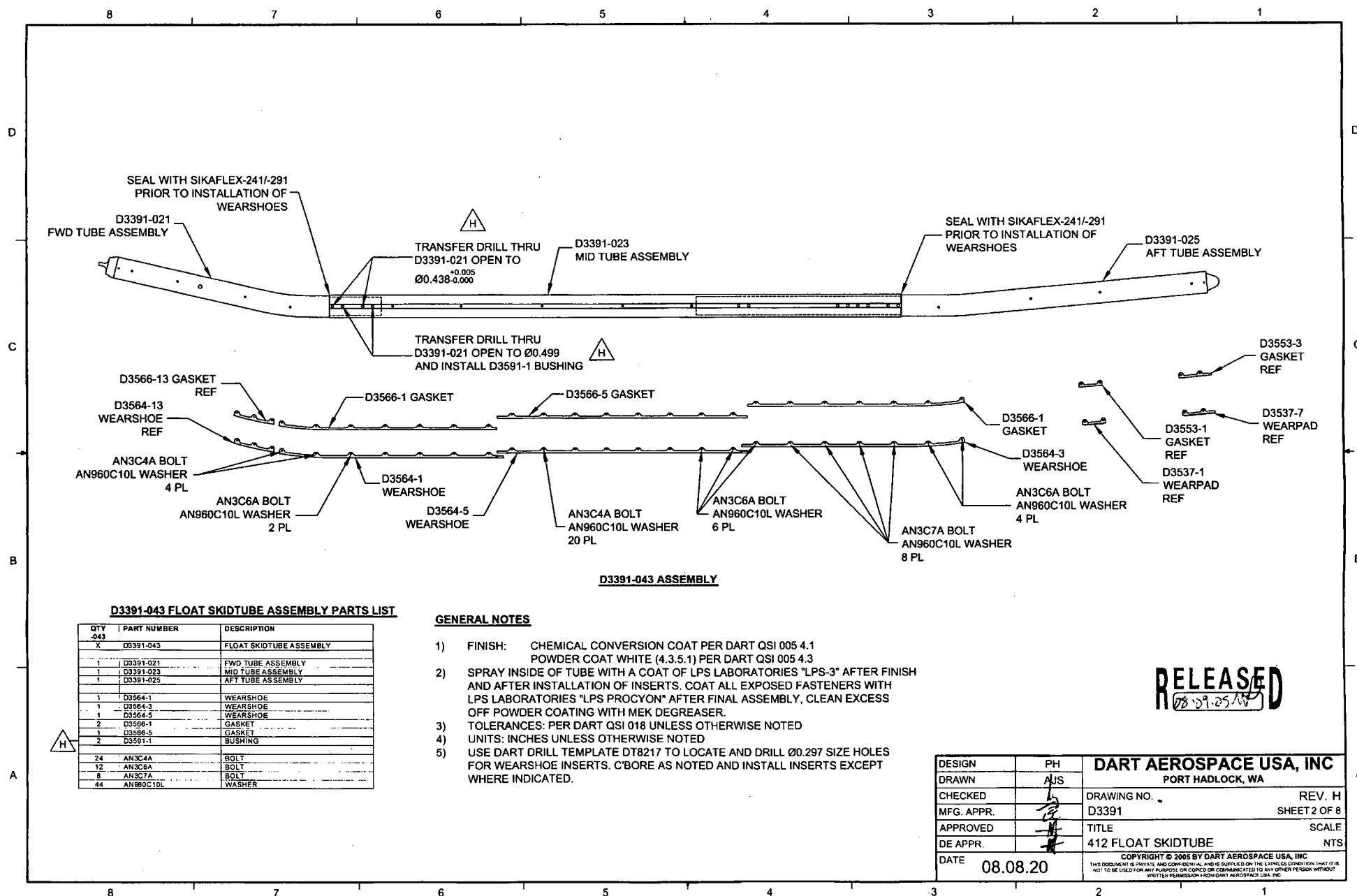
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

# GENERAL NOTES

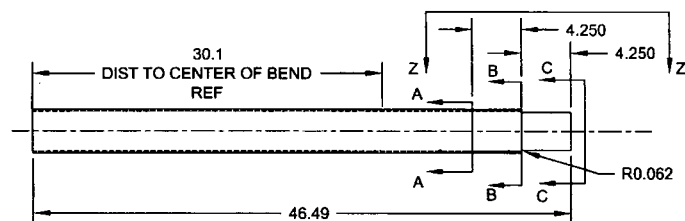
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. 2N C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. 2N C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.16
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	N
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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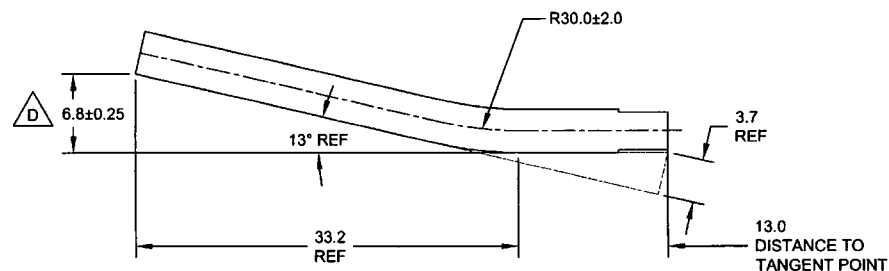
W/O 52783



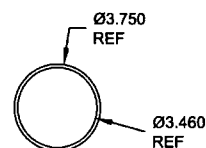
W/O 52783



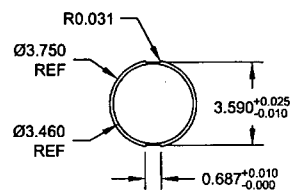
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



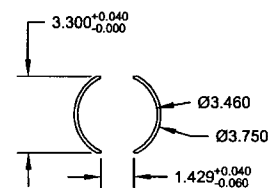
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



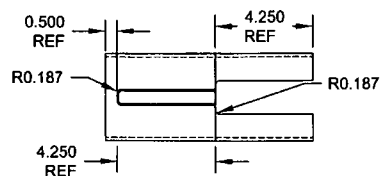
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**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X

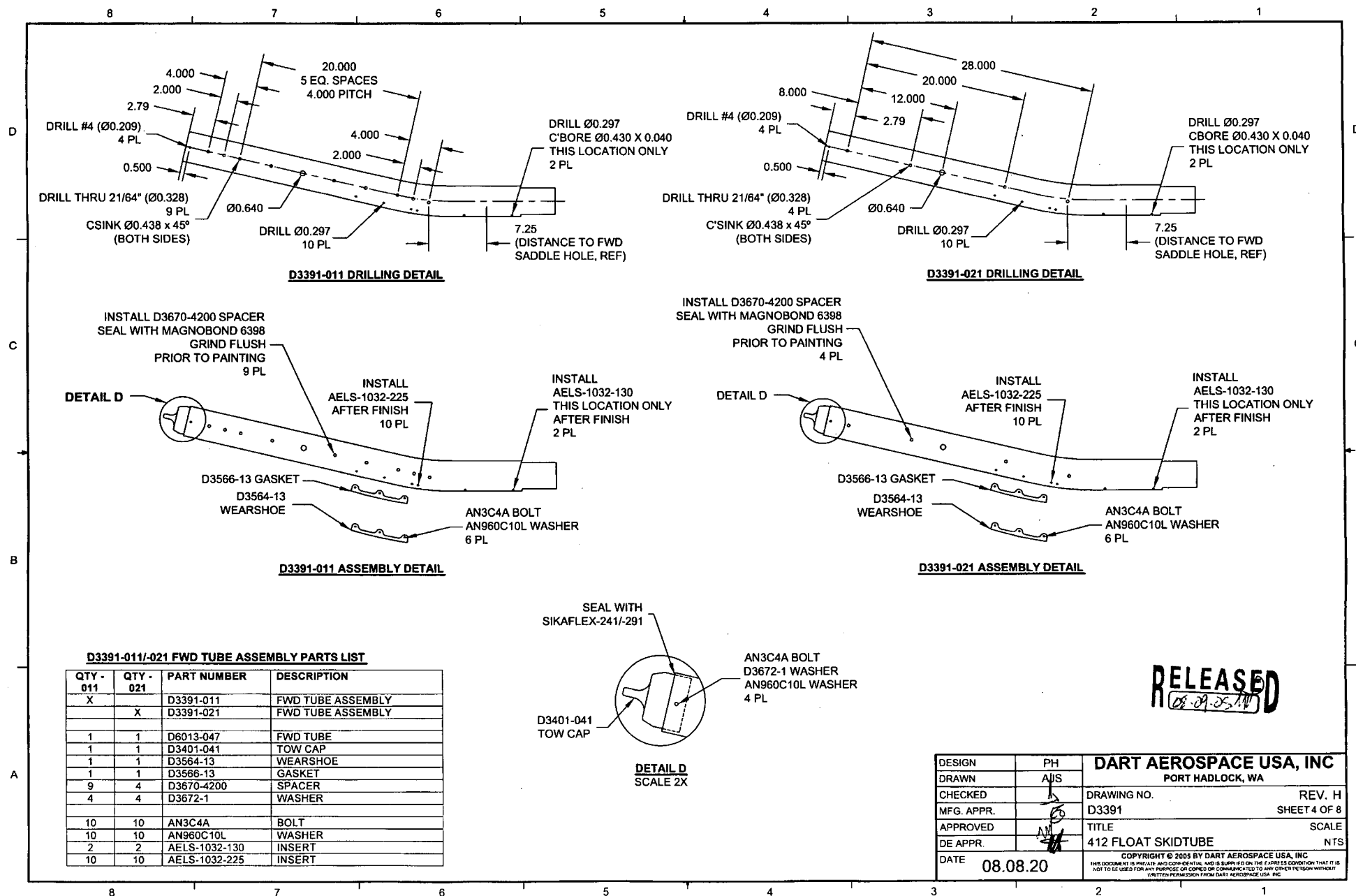


**VIEW Z-Z**  
SCALE 2X

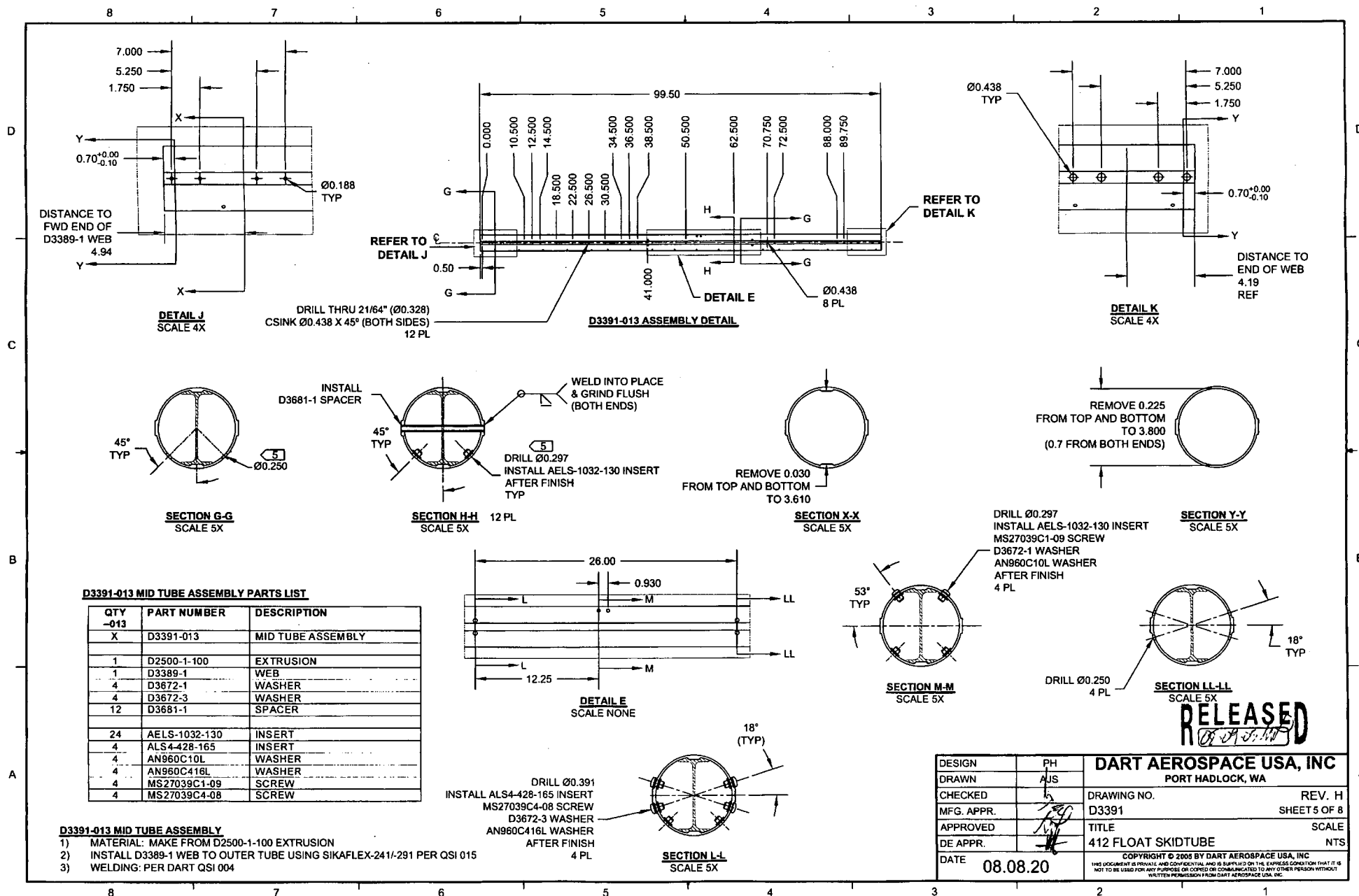
**RELEASED**  
08-05-11

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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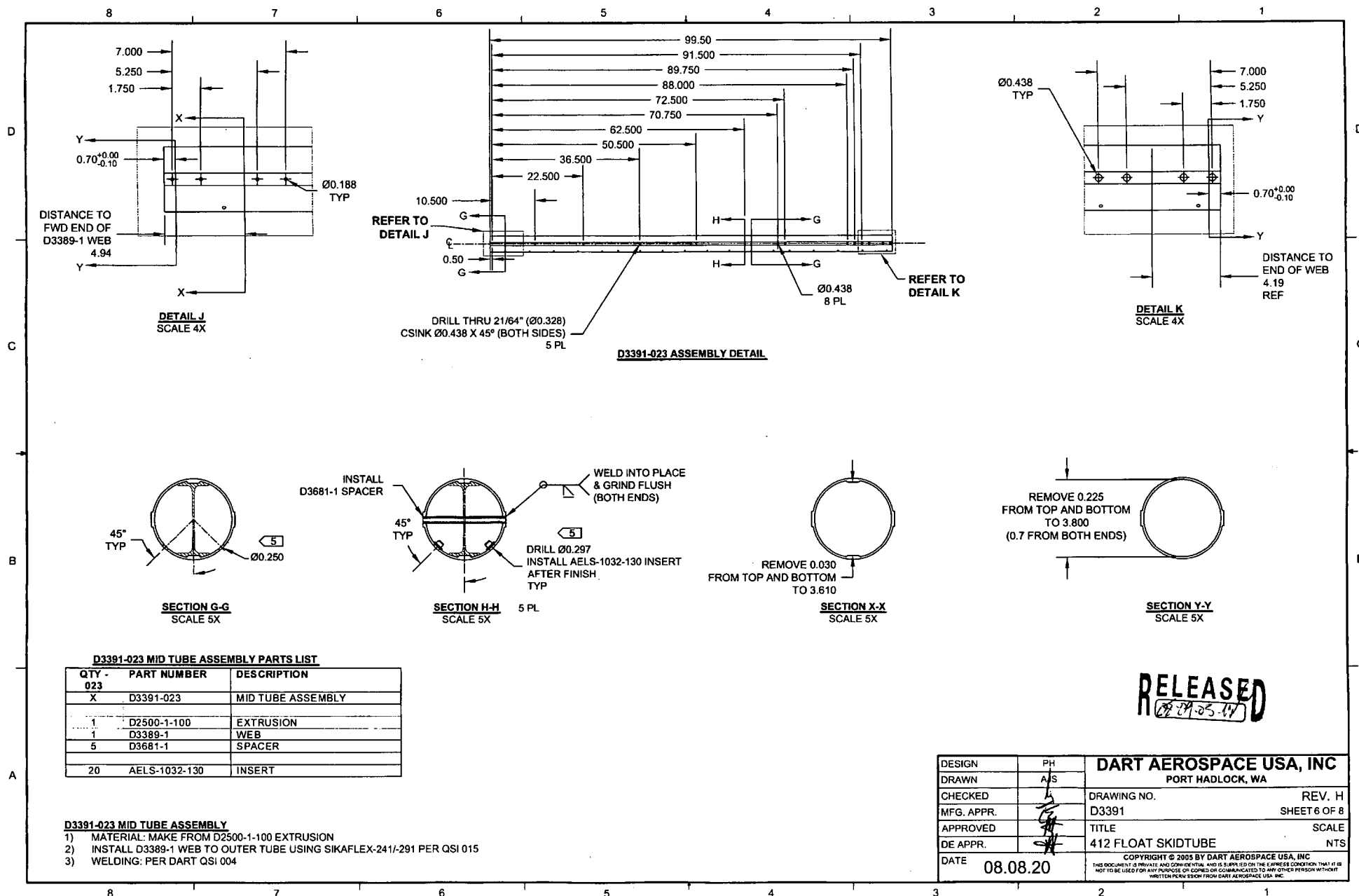


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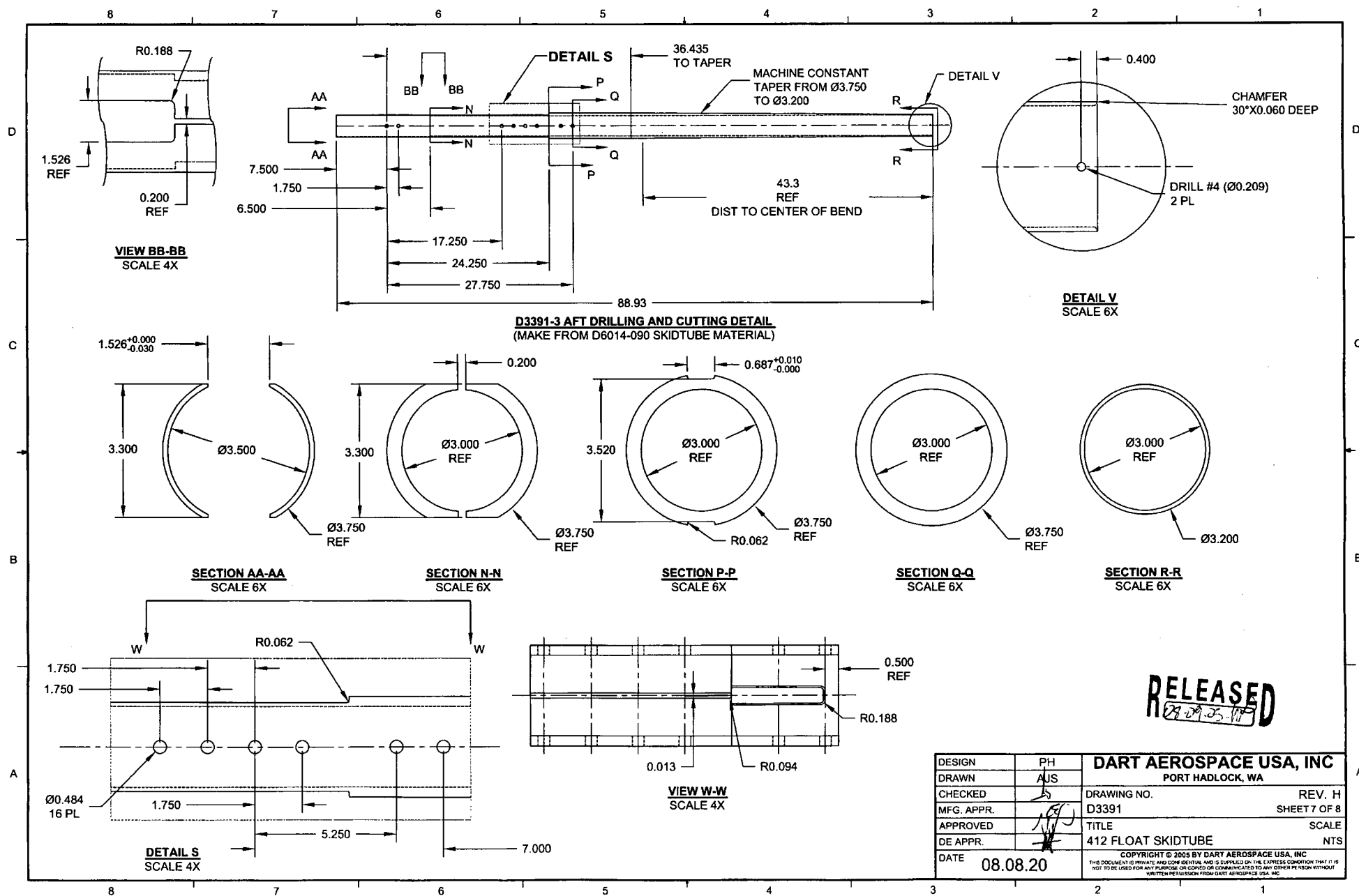




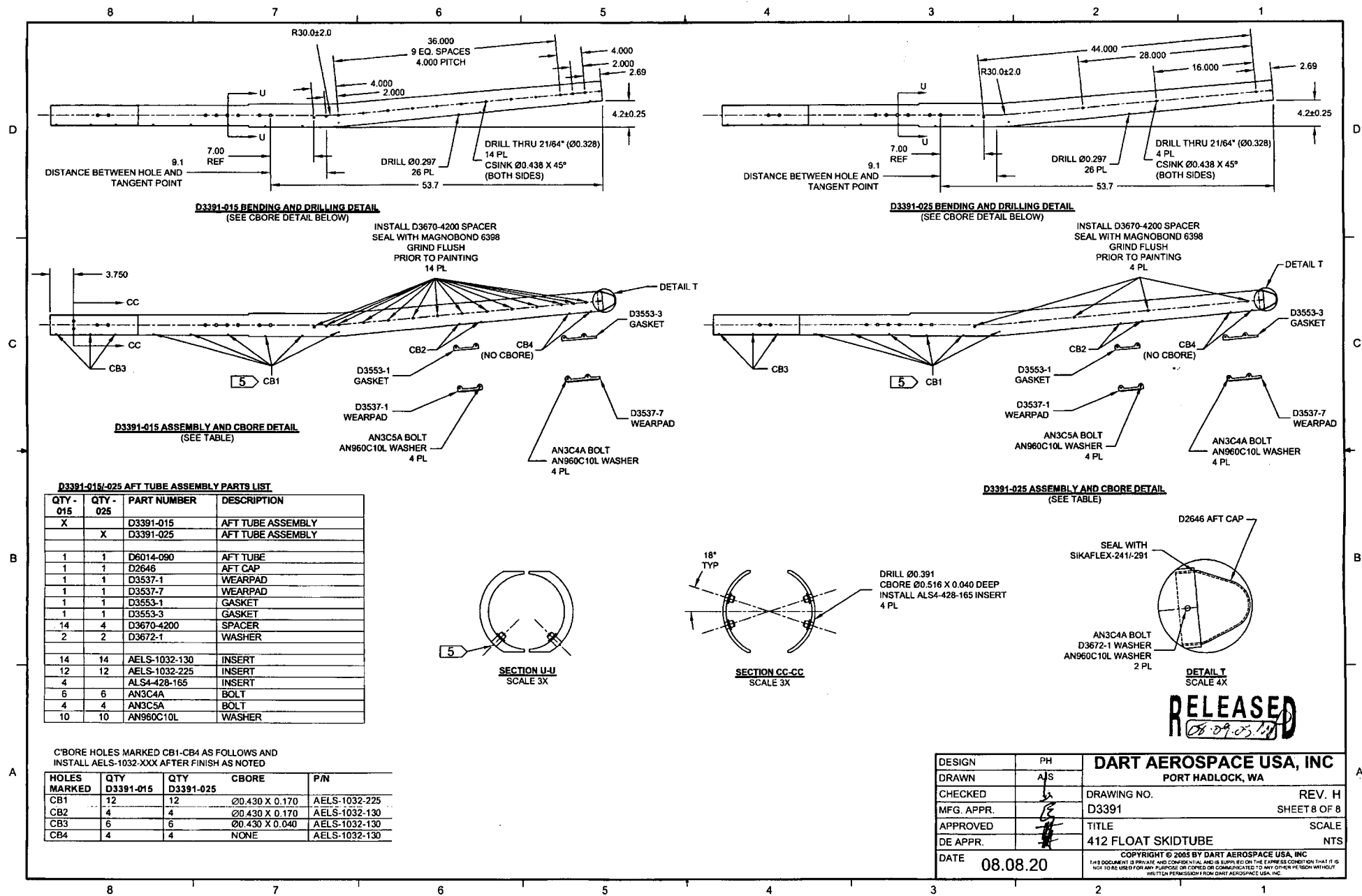
w/o 52783



w/o 52783



W/O 52783



DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	3	DRAWING NO.	REV. H
MFG. APPR.	3	D3391	SHEET 8 OF 8
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